

17

DART AEROSPACE LTD.	Work Order :	20563
Description: 206 Saddle, Outboard, Left Side	Part Number:	D2667-1
Drawing: D2667 Rev B	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>SL</i>	<i>04/03/24</i>	8
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (CD6101-003) RF 02/09/16 Batch No: <i>B20571</i>	<i>SL</i>	<i>04/07/13</i>	8
3	HAAS	Program batch number.	<i>SL</i>	<i>04/07/13</i>	8
4	QC	Inspect part number and batch number are programmed correctly.	<i>SL</i>	<i>04/07/13</i>	8
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed on <i>04/07/13</i> by <i>SL</i>	<i>SL</i>	<i>04/07/13</i>	8
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>SL</i>	<i>04/07/13</i>	8
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>SL</i>	<i>04/07/13</i>	8
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>SL</i>	<i>04/07/13</i>	8
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>SL</i>	<i>04/07/13</i>	8
12	METAL	Deburr	<i>SL</i>	<i>04/07/13</i>	8
13	HAAS	Inspect Level 1	<i>SL</i>	<i>04/07/13</i>	8
14	QC	Inspect Level 8	<i>SL</i>	<i>04/08/13</i>	8
15	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>SL</i>	<i>04/08/13</i>	8
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>SL</i>	<i>04/08/13</i>	8
17	QC	Inspect Level 3	<i>SL</i>	<i>04/08/13</i>	8
18	STORES	Pack in foam, identify and stock.	<i>SL</i>	<i>04/08/13</i>	8
19	EXPEDITING	Close Work Order Job Cost / Part <i>129.88 546 04/08/13</i> (8)	<i>SL</i>	<i>04/08/13</i>	8

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	

RELEASED

DEC 18 2000

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20563 D2667-1		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04/07/13	5	1 saddle scrap	mf	destroy and replace	EP 04/07/14	B 04-08-03	B PST 04-08-03	B 04-08-03

PAR#: N/A Fault Category: Manuf. CNC DQA: 11 Date: 04.08.12

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: 11 Date: 04.08.12

DART AEROSPACE LTD	Work Order:	20563
Description: 206 Saddle, Outboard, Left side	Part Number:	D2667-1
Inspection Dwg: D2667 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.108	0.103	0.113	0.110		
B	0.100	0.140		0.108	0.111	0.111	0.110		
C	0.100	0.140		0.135	0.123	0.130	0.129		
D	0.210	0.230		0.228	0.228	0.220	0.227		
E	1.245	1.255		1.251	1.248	1.250	1.250		
F	1.245	1.255		1.250	1.249	1.249	1.249		
G	5.990	6.010		6.001	6.002	6.002	6.002		
H	0.510	0.515		0.511	0.511	0.512	0.512		
I	1.674	1.684		1.677	1.677	1.677	1.677		
J	1.995	2.005		1.999	1.999	1.999	1.999		
K	0.257	0.262	DT8683	✓	✓	✓	✓		
L	0.312	0.317	DT8686	✓	✓	✓	✓		
M	0.235	0.240		0.249	0.238	0.239	0.239		
N	0.100	0.140		0.116	0.119	0.118	0.115		
O	1.040	1.060		1.049	1.047	1.050	1.049		
P	0.490	0.510		0.502	0.508	0.503	0.504		
Q	3.609	3.619		3.611	3.611	3.611	3.611		
R	2.470	2.510		2.484	2.482	2.483	2.484		
S	0.240	0.270		0.261	0.268	0.252	0.254		
T	0.100	0.180		0.128	0.121	0.124	0.123		
U	0.313	0.318	DT8686	✓	✓	✓	✓		
V	1.125	1.145		1.132	1.131	1.138	1.138		
W	1.565	1.585		1.569	1.571	1.577	1.575		
X	R1.675	R1.695		1.690					
Y	0.940	1.010		0.003					
Z	0.100	0.120		0.120					
AA	2.490	2.510		2.500					
AB	R0.515	R0.535		R0.525					
AC	R0.240	R0.260		R0.250					
AD	0.365	0.385		0.279					
AE	0.040x45°	0.060x45°		0.020					
AF	R0.490	R0.510		R0.500					
AG	0.787	0.807		0.799					
AH	0.427	0.447		0.450					
Accept/Reject									

Measured by:	<i>ML</i>
Date:	04/07/13

Audited by:	<i>SL</i>
Date:	04/10/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	<i>RF</i>

RELEASED
03.06.18 *RF*

350 + .158 = 408

DART AEROSPACE LTD	Work Order:	20563
Description: 206 Saddle, Outboard, Left side	Part Number:	D2667-1
Inspection Dwg: D2667 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. B and record below:

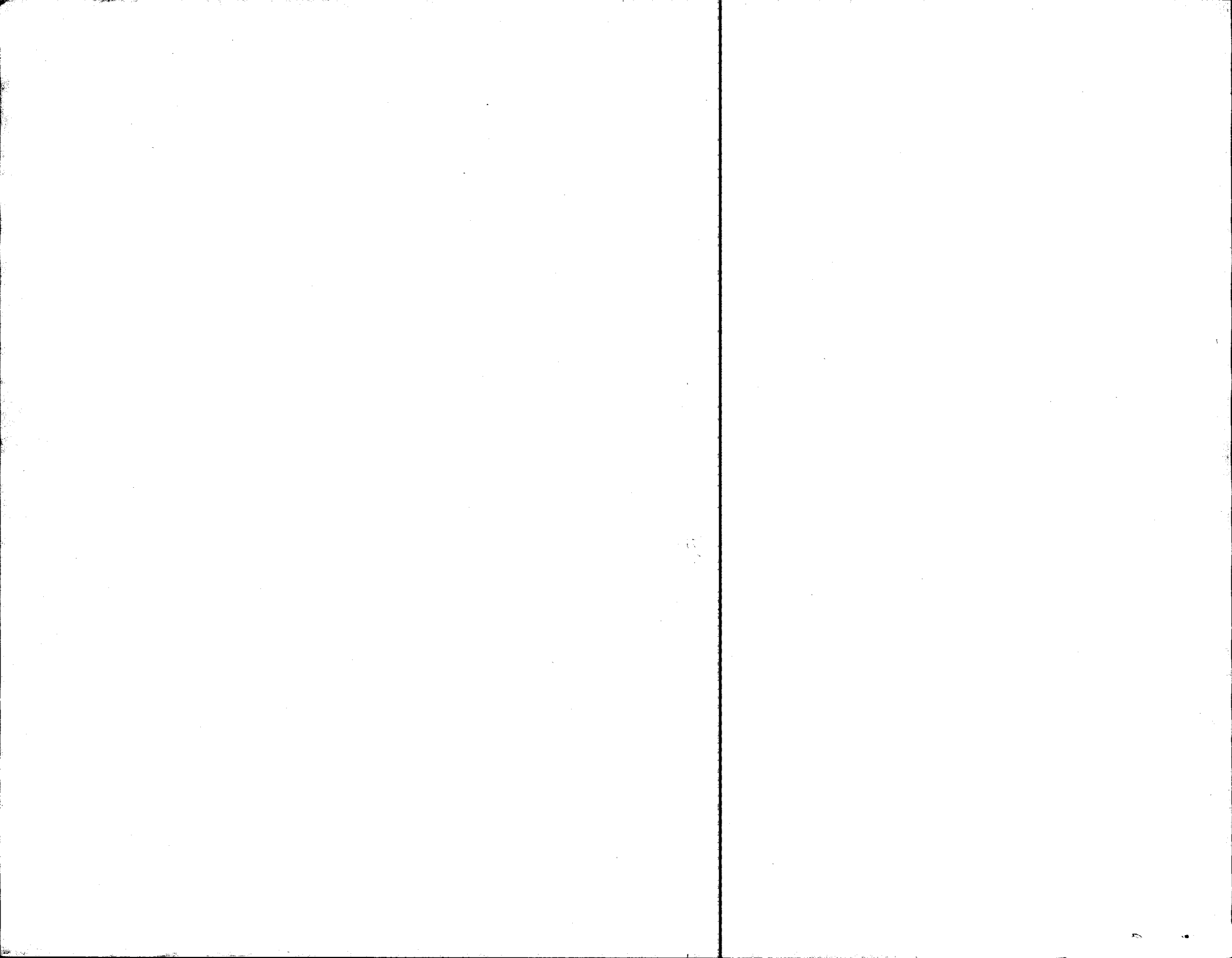
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.113	0.116	0.117	0.116		
B	0.100	0.140		0.112	0.110	0.114	0.115		
C	0.100	0.140		0.129	0.128	0.134	0.132		
D	0.210	0.230		0.227	0.227	0.226	0.228		
E	1.245	1.255		1.250	1.250	1.250	1.251		
F	1.245	1.255		1.251	1.250	1.250	1.249		
G	5.990	6.010		6.002	6.002	6.002	6.002		
H	0.510	0.515		0.511	0.512	0.512	0.512		
I	1.674	1.684		1.677	1.677	1.677	1.677		
J	1.995	2.005		1.999	1.999	1.999	2.006		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.115	0.114	0.116	0.113		
O	1.040	1.060		1.050	1.051	1.051	1.050		
P	0.490	0.510		0.501	0.502	0.501	0.502		
Q	3.609	3.619		3.612	3.612	3.611	3.611		
R	2.470	2.510		2.486	2.486	2.484	2.486		
S	0.240	0.270		0.256	0.259	0.262	0.260		
T	0.100	0.180		0.124	0.123	0.121	0.120		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.133	1.132	1.132	1.132		
W	1.565	1.585		1.574	1.570	1.570	1.569		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	04/07/13

Audited by:	<i>sf</i>
Date:	04/07/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	<i>[Signature]</i>

RELEASED
03.06.18 *[Signature]*



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 23, 2004
10:58 am

Work Order No : 0020563
Project Name : D2667-1
Project For : WK417
Work Order Type : Main
Main WO Number :
House Part Number : D2667-1
Description : Saddle, LH, Aft, Out
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 03-23-04
Est Finish Date : 04-22-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00